

Work Order ID 86575

July-05-12 11:40:34 AM

86575

Page 1

Item ID: D4463-13 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Tank Bottom
 Start Date: 7/05/12 Start Qty: 5.00 ***5*** Cust Item ID:
 Required Date: 7/09/12 Req'd Qty: 5.00 ***5*** Customer:
 Reference:

Approvals: Process Plan: [Signature] Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D4463	C

100

0.00

100

Waterjet

Memo

0.00

FLOW CNC Waterjet

Cut as per dwg

6661. 062

Prog rev: C
 Dwg rev: C

6 0 Jun 12-7-7

110

QC2- Inspect parts off machine FAI/FAIB

0.00

110

QC

Memo

0.00

Quality Control

6 0 Jun 12-7-7

120

QC8- Inspect parts - second check

0.00

120

QC

Memo

0.00

Quality Control

8/7/09

(x6) _____

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 *130* Brake NC Brake NC	Bend as per dwg Memo	0.00 0.00				6			12/07/09
140 *140* QC Quality Control	QC6- Inspect dimensions to drawing Memo	0.00 0.00				46			
150 *150* HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1 Memo	0.00 0.00				6	4		12.07.10

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp Stamp
160 *160* QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.00				<u>6X</u>			<u>12/07/10</u>
170 *170* Packaging Packaging	Identify as per dwg & Stock Location: <u>UNA</u> Memo	0.00 0.00				<u>6</u>	<u>9</u>		<u>12-07-10</u>
180 *180* QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.00				<u>CK</u>	<u>12/7/10</u>		

MF
12-07-10

Picklist Print

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Work Order ID: 86575

Parent Item: D4463-13

Parent Item Name: Tank Bottom

Start Date: 7/05/12

Required Date: 7/09/12

Start Qty: 5.00

Required Qty: 5.00

Comments: IPP REV:A 11.11.22 NEW ISSUE DD VERF:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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M6061T6S.063

Purchased

No

100

sf

505.4868

2.748

14.463158

6061-T6 .063 Sheet

Sm 12-7-7

Location

Loc Qty

Loc Code

MAT021

505.4868320

113608

0

116308

5.01556842

117285

67.544

119331

44.2

119802

5.94

120218

15.86

120866

64.8126316

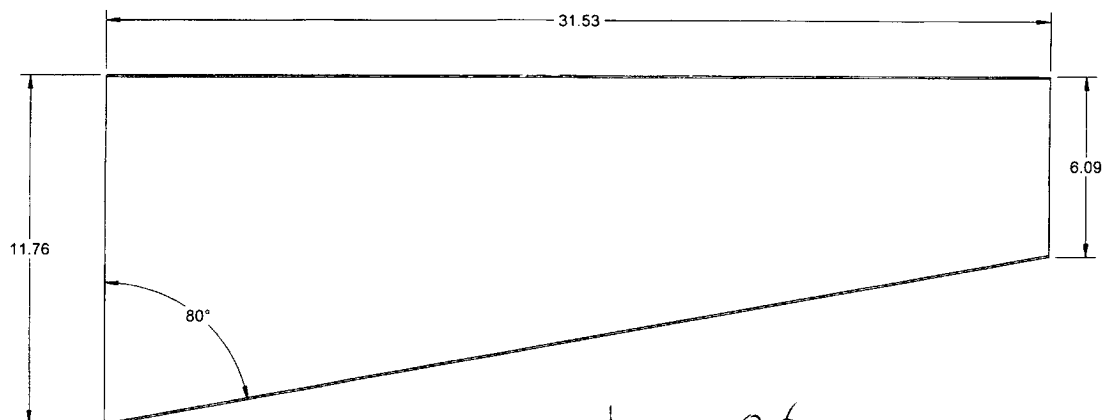
121805

302.114632

121805

R0.19
TYP

0.50
TYP



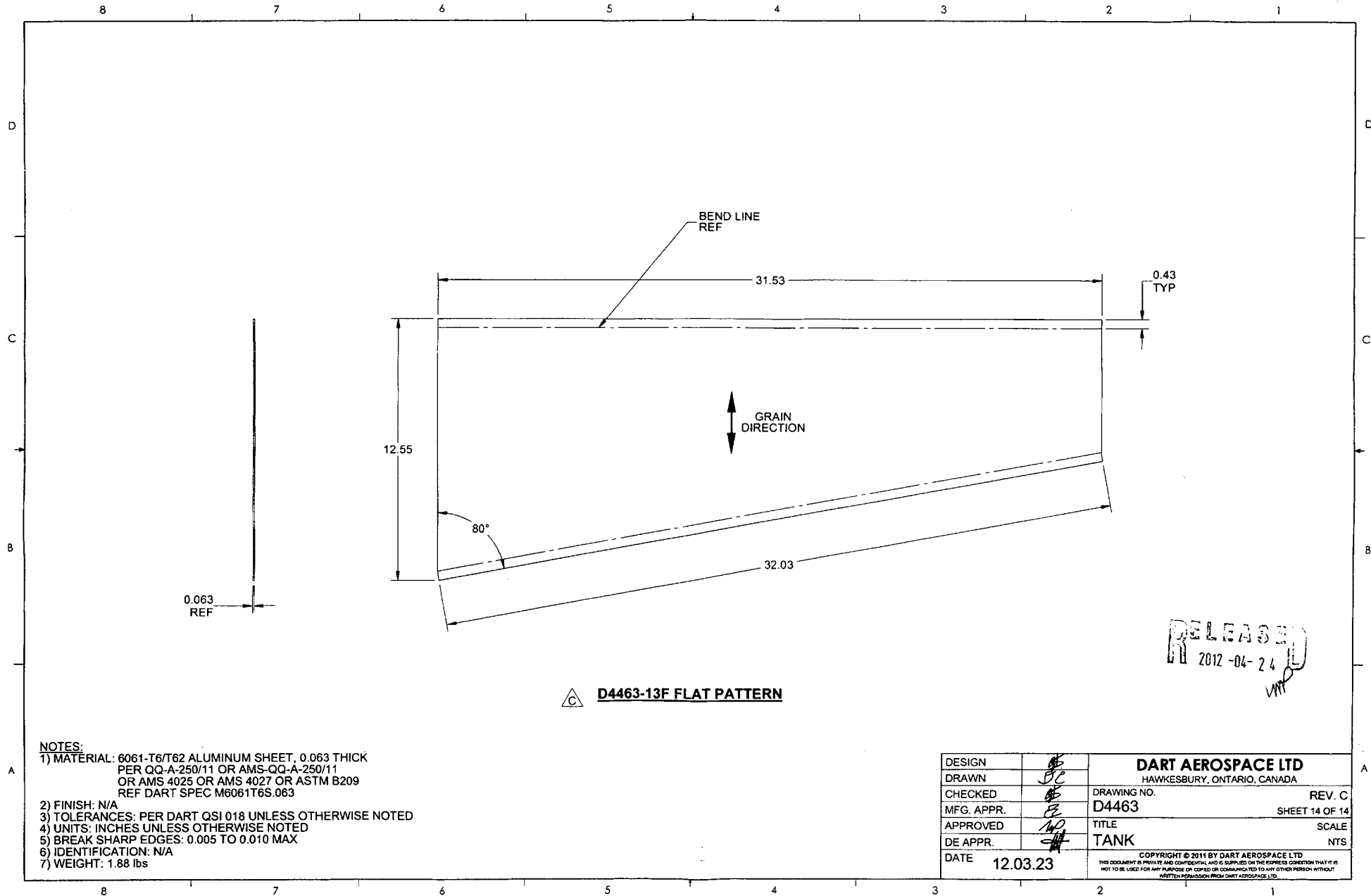
D4463-13 TANK BOTTOM

NOTES:

- 1) MATERIAL: MADE FROM D4463-13F
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 1.88 lbs

DESIGN		DART AEROSPACE LTD	
DRAWN	<i>SC</i>	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>SC</i>	DRAWING NO.	REV. C
MFG. APPR.	<i>SC</i>	D4463	SHEET 13 OF 14
APPROVED	<i>SC</i>	TITLE	SCALE
DE APPR.	<i>SC</i>	TANK	NTS
DATE	12.03.23	<small>COPYRIGHT © 2011 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD</small>	

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2012-04-24



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